

# Work Order ID 59180

Thursday, May 27, 2010 1:16:15 PM



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Item ID:	D3166-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Basket Hoop				Stop	
Start Date:	5/27/2010	Start Qty:	12.00			
Required Date:	6/4/2010	Req'd Qty:	12.00			
Reference:						

Approvals:	Process Plan:		Date:	10-5-27	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3166	Rev A1								
100	Skidtubes	0.00							
	Small Fab								
Small Fab	Memo	0.00							
	Cut 3/4" x 3/4" square tubing 60.00" long.								
110	BENDING MACHINE - SKIDTUBES	0.00							
	CNC Bend 1								
CNC Delta 100 Bender	Memo	0.00							
	Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004.								
120	QC6- Inspect dimensions to drawing	0.00							
	QC								
Quality Control	Memo	0.00							
	Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)								

SAP  
10-05-27

(12)

10-5-31 (12)

P10

(12)

Siol 6/5/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3166-1 PAR #:  Fault Category: Large Fals NCR: Yes No DQA:  Date: 10/05/31  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed:  Date: 10/06/01

NCR: <u>59180</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-5-31	110	#rib under bent Found Qty 1 at inspection that is our Part Rt. Process.	<u>JSIM</u>	Scrap + Replace Qty <del>x 1</del> <del>Ref. process</del> M <u>1114482</u>	<u>SAE</u> 10-05-31	<u>JSIM</u>	<u>JSIM</u>	<u>1005-31</u>
		Rib under bent by 1.0" <del>(bent)</del> Rib was bent in middle of Qty of who operate added extra points to program and our Part Qty of Rib area works.	<u>JSIM</u>	- unable to re bend to fit Sg to be acceptable for welding Repair & couldn't save	<u>JSIM</u> 10/05/31	<u>JSIM</u>	<u>JSIM</u>	<u>1005-31</u>






NOTE: Date & initial all entries



**Work Order ID 59180**



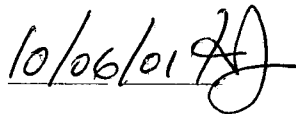
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Item ID: D3166-1 Accept  Setup Start   
Revision ID:  
Item Name: Basket Hoop Stop   
Start Date: 5/27/2010 Start Qty: 12.00  Cust Item ID:  
Required Date: 6/4/2010 Req'd Qty: 12.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u>  Memo	0.00  0.00		SAD 10-05-31		<u>12</u>			
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						10/06/01 	

10-05-31  
12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 59180



Parent Item: D3166-1



Parent Item Name: Basket Hoop

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP A ☐ 02.08.23 ☐ New issue ☐ KJ  
 IPP: B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ  
 Verified by: EC  
 IPP Rev:C 09-01-23 as per DEO D3166-A2 DD verified by:EC

Start Qty: 12.00

Required Qty: 12.00

M304TS0.750W.065

Purchased

No

100

f

1,187.136

5

63.15789



304 SQ Tube .75x.75x.065W



SAP 10-05-27

## Location

## Loc Qty

## Loc Code

MAT

187.1361

112398

0

114482

187.1361

WA

1000

114520

1000

63.15789

+5,203

DP

10-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

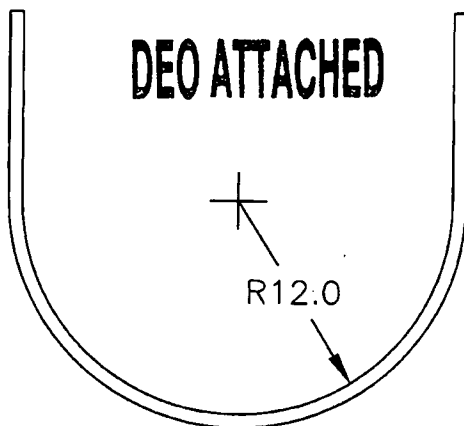
**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/-1 WAS 36.0	

RELEASED  
02.08.06

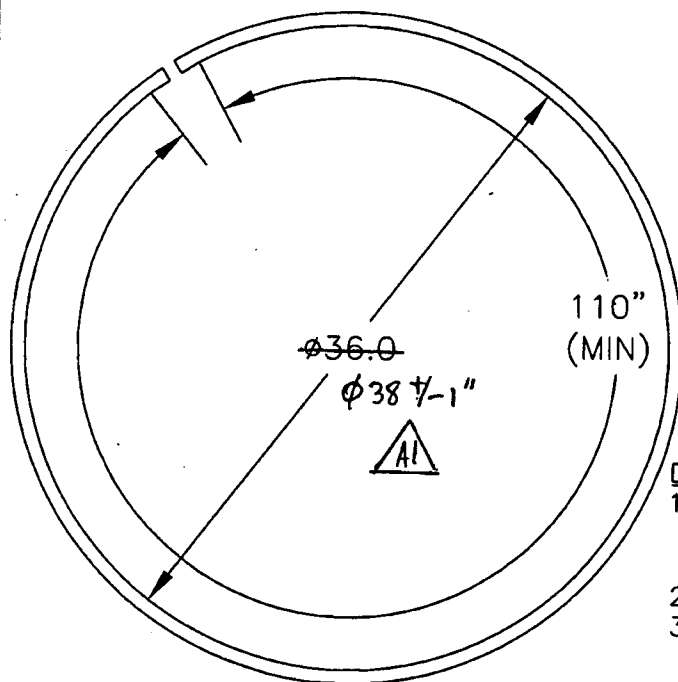
DEO ATTACHED



10.6 (REF, NEED 8.0 MIN)

D3166-1 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



D3166-3 BASKET HOOP

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DRAWING NO. D3166	TITLE BASKET HOOP	REV A1	<b>DART AEROSPACE LTD ENGINEERING ORDER</b>		D.E.O. NO. D3166-A-2	SHEET NO. 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.12.11	DATE 08.12.15	DATE 08/12/15	DATE 08/12/16		DATE 08.12.16		

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
60.00" LONG  
REF. DART SPEC M304TS0.750W.065

WAS:

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
120.00" LONG  
REF. DART SPEC M304TS0.750W.065

WAS:

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

*W/059180*

**RELEASED**  
08/12/16 *[Signature]*

REASON: SEE PAR 08-005

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries